

008612



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18700A
Job Sheet 184471



Part No: RBT18700A

Job Qty: 1 pcs

Part Name: Engine Stand C47 Adapter (2 Per Set)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18700A Rev A IPP Rev A 18.02.20 New issue DP Verify DD/IPP Rev. B 18.08.17 new DWG DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/10/18		0.00	0.10	Small Fab - 1	XLOAD 1	AP 2019/03/13 Michel
							Small Fab - 2		
							Small Fab - 3	XLOAD 2	
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/10/18		0.00	0.00	QC 5 - 10		MAR 13 2019 DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/10/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S161823



Part: RBT18700A

Job No: 184471

Serial No/Batch: S161823

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 03/13/19

				Packaging 3 - 6 - B4B	DAS	
				Packaging 3 - 7 - B4B	28	
				Packaging 3 - 8 - B4B	9-89	
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - FG	1 pcs	12/10/18	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
						2-88
						MAR 14 2019
Part Op 110 - small Fab - Assemble as per DWG see note 8 and 9. Descriptions: 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
91251A621	SOCKET HD CAP SCREWS 3/8-16 UNC x 5/8 BLACK	8 Ea (8 ea)	110-Small Fab - 1	S085254		
RBT18700A-1	C47 Adapter	2 pcs (2 ea)	110-Small Fab - 1	S130255		
RBT18700A-2	Bolt Modified	6 pcs (6 ea)	110-Small Fab - 1	S121950		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Small Fab - 1	91251A621	8	408	0		
	RBT18700A-1	2	3	0		
	RBT18700A-2	6	10	0		
Part Specifications						
Specifications could not be found.						



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RBT18700A
Job Sheet 184471



Part No: RBT18700A

Job Qty: 1 ea

Part Name: Engine Stand C47 Adapter (2 Per Set)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18700A Rev A IPP Rev A 18.02.20 New issue DP Verify DD/IPP Rev. B 18.08.17 new DWG DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/10/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		12/10/18	0.00	0.10	Small Fab-3		
120	QC	1 pcs		12/10/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/10/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/10/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - Assemble as per DWG see note 8 and 9.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18700A-1	C47 Adapter	2 Ea (2 ea)	90-Start up Operation	
91251A621	SOCKET HD CAP SCREWS 3/8-16 UNC x 5/8 BLACK	8 Ea (8 ea)	110-Small Fab	
RBT18700A-2	Bolt Modified	6 Ea (6 ea)	110-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT18700A-1	2	0	0
110-Small Fab	91251A621	8	443	0
	RBT18700A-2	6	1	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



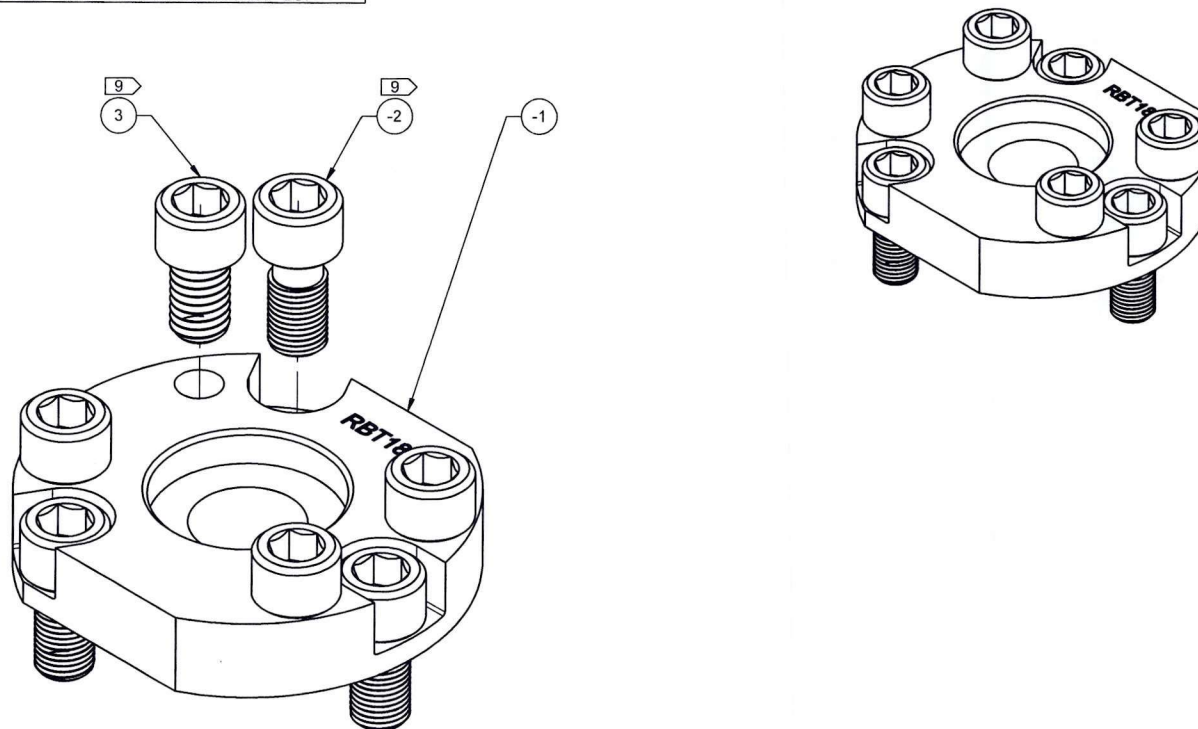
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

ITEM #	QTY	PART #	PART TITLE
-1	2	RBT18700A-1	C47 ADAPTER
-2	6	RBT18700A-2	BOLT MODIFIED
3	8	McMaster#91251A621 OR EQUIV	STEEL SOCKET HEAD SCREW 3/8"-16 x 5/8" LG.

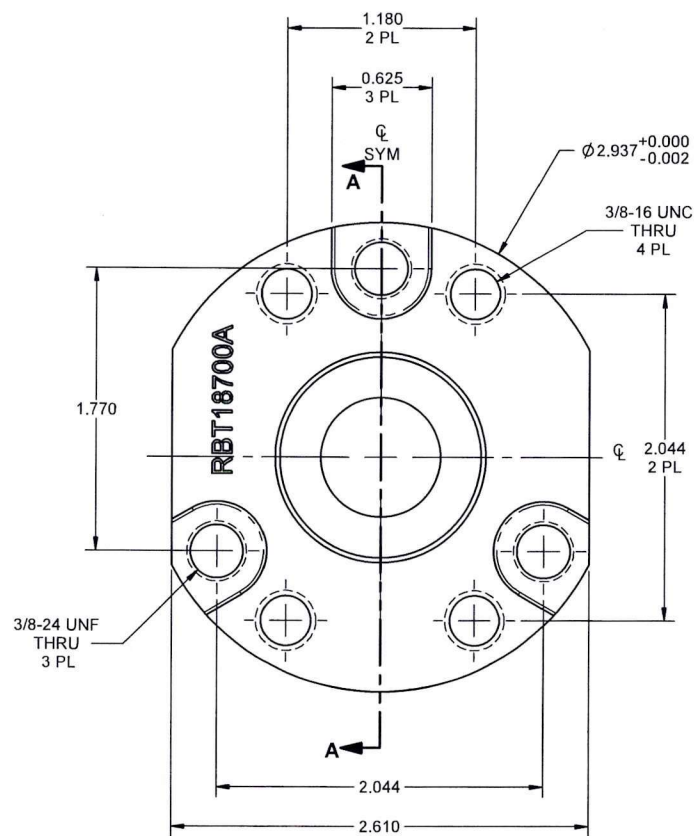


RBT18700A ENGINE STAND C47 ADAPTER (2 PER SET)
ONLY 1 SHOWN FOR CLARITY

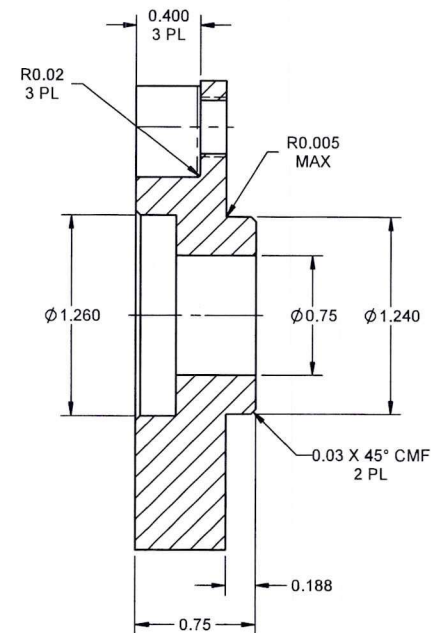
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) INSTALL ITEM -2 AND ITEM 3 HAND TIGHT

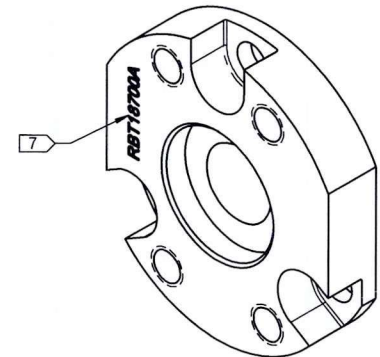
A	NEW ISSUE, REDRAWN FROM REDBARN AUTOCAD FILE		18-785	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM			
CHECKED	VM	TOOL PART #	REV. A	
MFG. APPR.	DP	RBT18700A	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	NTS
DATE 8/17/2018		ENGINE STAND C47 ADAPTER (2 PER SET)		
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RBT18700A-1 C47 ADAPTER



SECTION A-A



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N APPROXIMATELY AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RBT18700A	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	8/17/2018	ENGINE STAND C47 ADAPTER (2 PER SET)	NTS
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